

C6649142

MODEL 700TM M24

Model SWSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

DUPONT
REG. U.S. PAT. & TM. OFF.

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6649142

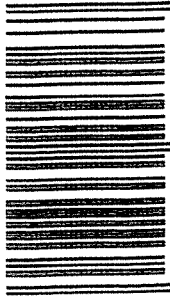
ORDER NO.
5716

MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649142

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649142

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 8 1991	CS
	Magnaflux Bolt		JUL 8 1991	CS
615	Rollmark Caliber		JUL 8 1991	CS
617	Drill and Tap Sight Holes		JUL 8 1991	EB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		6/27/91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KA
	C) Inspect Ejector Hole for Chamfer		8/29/91	KA
	D) Oil Firing Pin Ass'y		8/29/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9/12/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7½	8			9-4-91	DH
	G) Safety Off Force	2	2	2½			9-4-91	DH
	H) Trigger Pull Test & Retainability						9/4/91	DH
	I) Firing Pin Indent	.020	.020	.020			9-4-91	DH
	J) Assemble Stock						9/4/91	KS
	K) Assemble Swivel Studs						9-12-91	AC
	L) Attach Front and Rear Sight Assemblies						9/4/91	KS
	M) Iron Sight Alignment						9/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	KS
	O) Attach Scope to Rifle						9/4/91	KS
	P) Detach & Attach Scope 20 Times						9/4/91	KS
640	Gallery Target & Test						9/7/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						9/7/91	KT
655	Final Inspection							
	A) Headspace						9-12-91	AC
	B) Trigger Pull	2.37	2.39	2.46	2.41	2.46	9-12-91	DH
	C) Function						9-12-91	AC
660	Pack						9-11-91	KS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06649142

DATE 9/4/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.35	2.46	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.36	2.38	2.39	
PULL #3	2.42	2.33	2.33	2.46	
PULL #4	2.38	2.47	2.44	2.41	
PULL #5	2.25	2.37	2.46	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.63	3.63		
PULL #2	3.57	3.64		
PULL #3	3.60	3.36		
PULL #4	3.53	3.50		
PULL #5	3.50	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.25		4.28
PULL #2	4.38	4.23		4.17 4.34
PULL #3	4.21	4.28		4.38
PULL #4	4.25	4.32		4.27
PULL #5	4.40	4.28		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649142
7 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.122201
1 TO 2	.13005
1 TO 3	.0295466
1 TO 4	.139864
1 TO 5	.219401

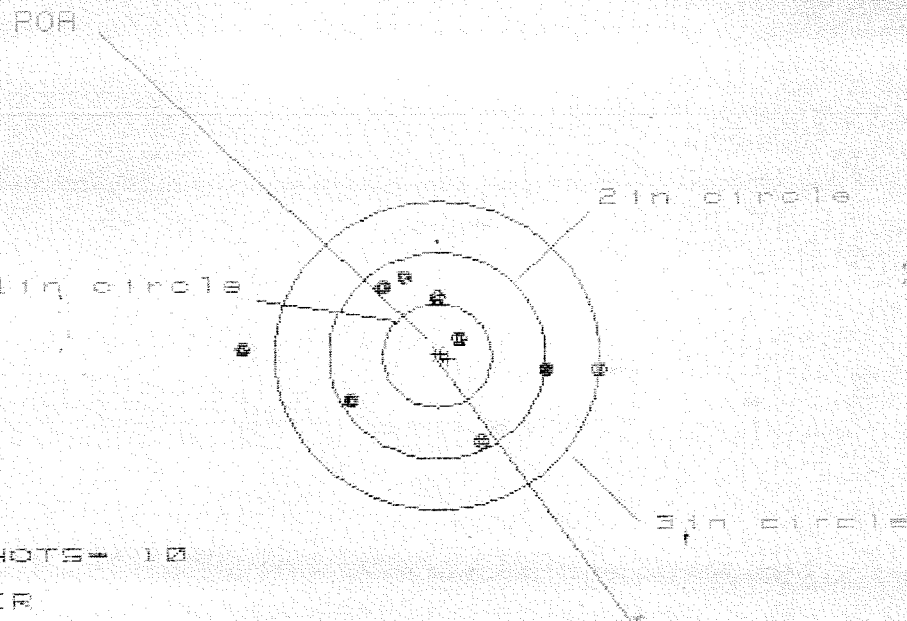
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0872
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0990772
THE AMP FOR THIS RIFLE IS: .8842

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649142

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 9

3in = 0

HS= 3.354

VS= 1.639

GS= 3.365

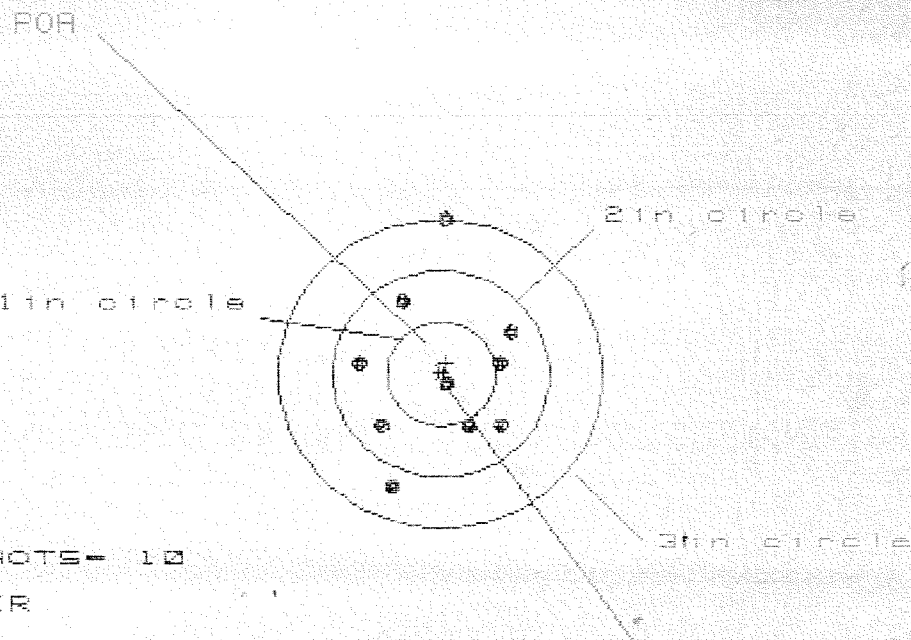
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.504	1.299	.916
MINIMUM X	:	-1.850	-1.020	-.858
MAXIMUM Y	:	.764	.776	.758
MINIMUM Y	:	-.875	-.863	-.881
CENTROID X	:	-.096	.109	-.053
CENTROID Y	:	.030	.018	.036
POA TO CENTROID in.	:	.101	.111	.064
MIN RADIUS	:	.329	.235	.294
MEAN RADIUS	:	.983	.866	.804
MAX RADIUS	:	1.853	1.307	.960
HORIZONTAL SPREAD	:	3.354	2.319	1.774
VERTICAL SPREAD	:	1.639	1.639	1.639
EXTREME SPREAD	:	3.365	2.334	1.840
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.371

VS= 2.538

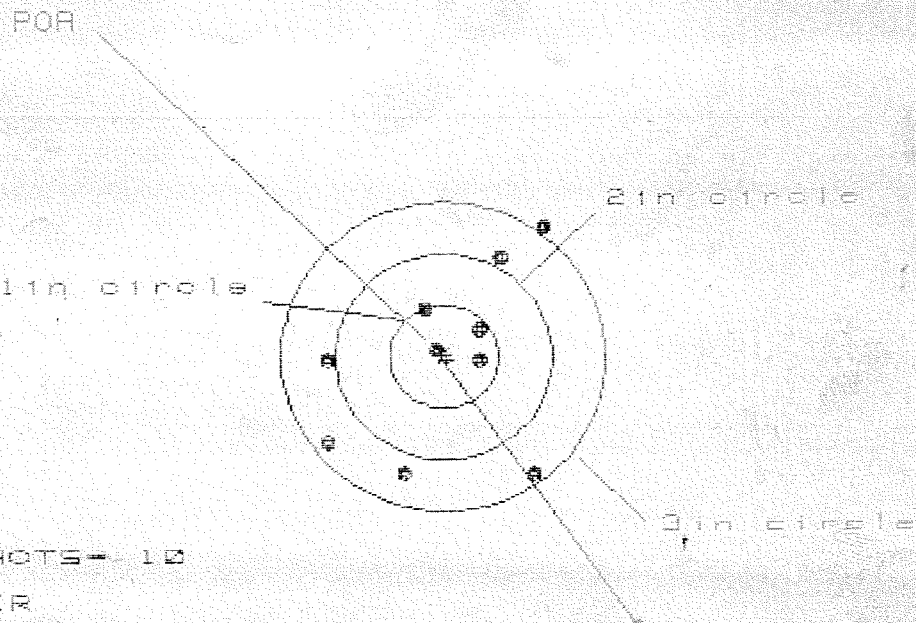
GS= 2.598

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.644	.653	.594
MINIMUM X	:	-.727	-.718	-.777
MAXIMUM Y	:	1.470	.836	.723
MINIMUM Y	:	-1.068	-.984	-.455
CENTROID X	:	-.046	-.055	-.004
CENTROID Y	:	-.110	-.274	-.161
POA TO CENTROID in.	:	.120	.279	.161
MIN RADIUS	:	.108	.057	.073
MEAN RADIUS	:	.758	.656	.605
MAX RADIUS	:	1.472	1.020	.852
HORIZONTAL SPREAD	:	1.371	1.371	1.371
VERTICAL SPREAD	:	2.538	1.740	1.178
EXTREME SPREAD	:	2.598	1.832	1.530
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Sep 1981

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 9

HS = 1.975

VS = 2.403

GS = 2.847

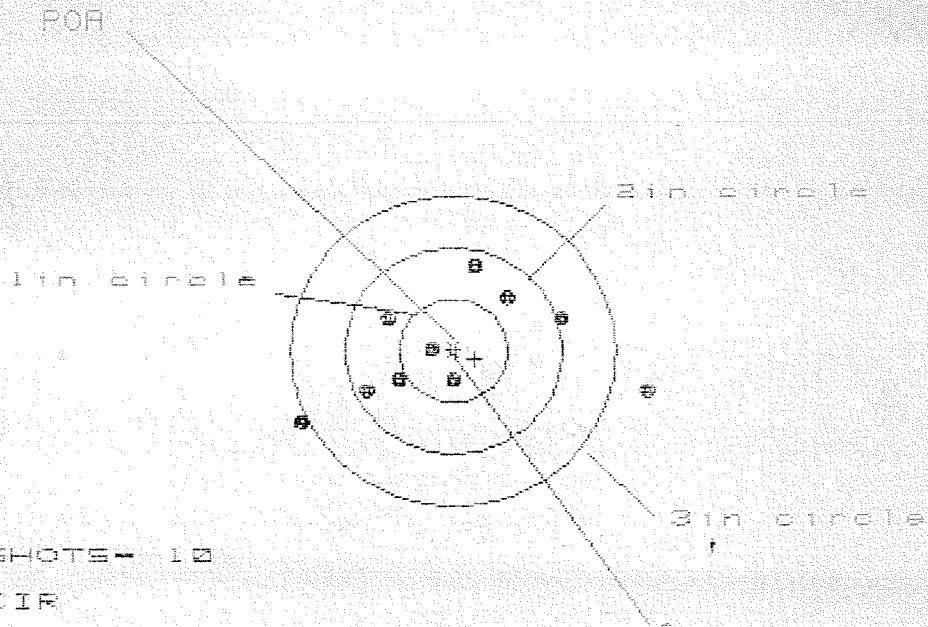
PATTERN # 3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.946	.720
MINIMUM X	-1.089	-.990	-.872
MAXIMUM Y	1.246	1.117	.998
MINIMUM Y	-1.157	-1.018	-1.137
CENTROID X	-.024	-.122	-.240
CENTROID Y	.033	-.106	.013
POA TO CENTROID in.	.040	.161	.241
MIN RADIUS	.149	.229	.146
MEAN RADIUS	.907	.858	.774
MAX RADIUS	1.529	1.340	1.231
HORIZONTAL SPREAD	1.975	1.936	1.592
VERTICAL SPREAD	2.403	2.135	2.135
EXTREME SPREAD	2.847	2.390	2.390
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.214

VS= 1.451

GS= 3.228

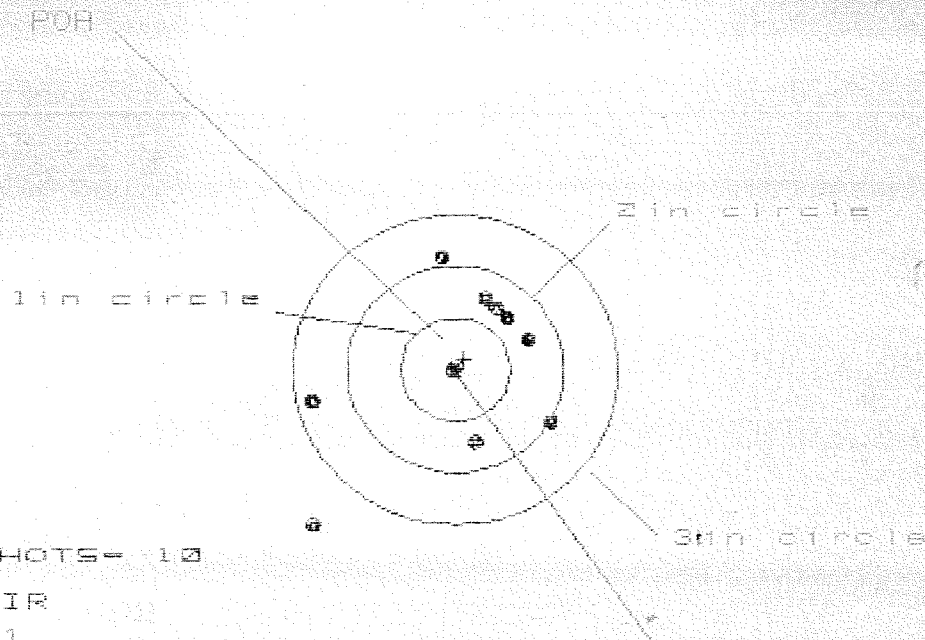
CENTROID *

PATTERN #	1	4	9
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.826	1.186	1.038
MINIMUM X	-1.388	-1.185	-0.790
MAXIMUM Y	.791	.751	.664
MINIMUM Y	-.660	-.700	-.521
CENTROID X	-.197	-.400	-.252
CENTROID Y	.083	.123	.210
POA TO CENTROID in.	.214	.418	.328
MIN RADIUS	.170	.041	.133
MEAN RADIUS	.863	.716	.643
MAX RADIUS	1.861	1.376	1.065
HORIZONTAL SPREAD	3.214	2.371	1.818
VERTICAL SPREAD	1.451	1.451	1.185
EXTREME SPREAD	3.228	2.583	1.970
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 8		

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CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.163

VS= 2.644

GS= 2.910

PATTERN # 1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.839	.695	.511
MINIMUM X	-1.324	-1.468	-.415
MAXIMUM Y	1.093	.921	.857
MINIMUM Y	-1.551	-.855	-.919
CENTROID X	-.073	.071	.235
CENTROID Y	-.098	.074	.138
POB TO CENTROID in.	.123	.103	.290
MIN RADIUS	.087	.308	.294
MEAN RADIUS	.910	.738	.589
MAX RADIUS	2.025	1.555	.952
HORIZONTAL SPREAD	2.163	2.163	.926
VERTICAL SPREAD	2.644	1.776	1.776
EXTREME SPREAD	2.910	2.170	1.850
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		